

Work Order ID 64144

PRELIMINARY ISSUE

Page 1

Thursday, November 25, 2010 3:58:03 PM

Item ID: D4298-024

Accept



Setup Start



Revision ID: PPELIM

Stop



Item Name: Serrated Adjustment Washer

Start Date: 11/25/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 12/3/2010 Req'd Qty: 1.00

Customer:



Reference:

Approvals:

Process Plan:

Date: 10/11/26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4298	PAT Rev A

100		0.00							
Doosan	Memo	0.00							
Doosan Lathe									

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

- Add by 5/16/12 hole to be transfered diller @ assembly

8/10/12/14

(AS)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries



Work Order ID 64144

Thursday, November 25, 2010 3:58:03 PM

Page 2

Item ID: D4298-024 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Serrated Adjustment Washer
Start Date: 11/25/2010 Start Qty: 1.00  Cust Item ID:
Required Date: 12/3/2010 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo	0.00 0.00		<u>Sp 10/12/15</u>		<u>(8)</u>			
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

MF
10-12-15

POSITIVE RECALL

EFFECTIVE 10.11.29AUTH AARELEASED 7DATE 10.12.17checked stock qty 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, November 25, 2010 3:58:06 PM

Work Order ID: 64144

Parent Item: D4298-024

Parent Item Name: Serrated Adjustment Wash



Start Date: 11/25/2010

Required Date: 12/3/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 10.11.25 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6RT.000

Purchased

No

f

13.6800

0.0161

0.016947



ROUND BAR 1.00"



31 10/12/14

M303R 1.00

Location

Loc Qty

Loc Code

MAT

11.5

115609

11.5

MAT013

2.18

108876

1.88

113457

0.3

CE

10.12.13

115774

3 PA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 64144
Description: Sealed Washer		Part Number: 14298-024
Inspection Dwg: 14298	Rev: 1.0 ERA-024	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

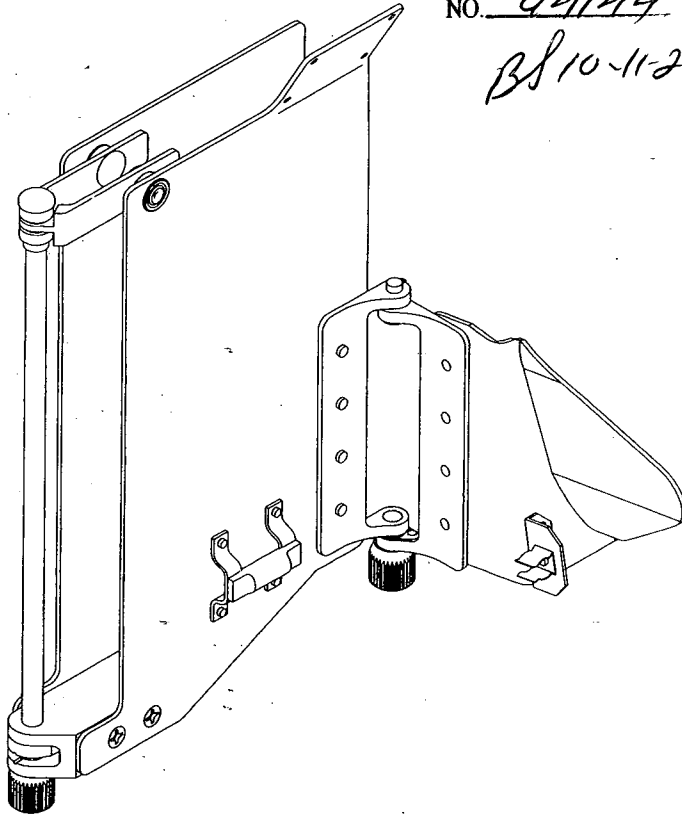
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.46	$\pm .030$.442	/		Visual	SA-9
.68	}	.672	/			
.040		.050	/			
.070		.085	/			
.016		.016	/			
.024		.034	/			
15°		15°	/			
.06		.050	/			
Ø.257		Ø.260	/			
0.034	$\pm .000$	0.034	/			JM-03

Measured by: SA	Audited by: S	Prototype Approval:	N/A
Date: 10/12/14	Date: 10/12/14	Date:	N/A

at inspect era Dwg -024

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

NO. 94144
BS 10-11-26



			4		(37)	AN426AD4-()	RIVET										
			4		(36)	AN426AD3-()	RIVET										
			1		(35)		C--CLIP										
			2		(34)	MS27980-6B	SOCKET, SNAP FASTENER										
			2		(33)	MS27980-1B	BUTTON, SNAP FASTENER										
				1 1	(32)	MS27980-9B	POST, SNAP FASTENER										
				1 1	(31)	MS27980-7B	STUD, SNAP FASTENER										
					4	(30)	MS24693-C246	SCREW									
				1	(29)	MS171441	PIN, SPRING										(ALT P/N NAS561C2-13)
				1	(28)	MS24665-103	COTTER PIN										
				1	(27)	MS20392-3C15	PIN, STRAIGHT HEADED										
				3	(26)	NAS1149D0332J	WASHER										
				3	(25)	MS27039C1-09	SCREW										
1	1		1	1	(24)	-024	SERRATED ADJUSTMENT WASHER					STAINLESS STEEL					
				1	(23)	-023	PIN					STAINLESS STEEL					
			1		(22)	-022	PIN TOPPER					STAINLESS STEEL					
				1	(21)	-021	MACHINE BOLT					STAINLESS STEEL					
				2	(20)	-020	KNOB					6061-T6 ALUM.					
1					(19)	-019	MACHINED OUTER					6061-T6 ALUM.					
	1				(18)	-018	MACHINED INNER					6061-T6 ALUM.					
				2	(17)	-017	CLIP STOP MOUNT					6061-T6 ALUM.					
				1	(16)	-016	GLIP STOP					6061-T6 ALUM.					
			1		(15)	-015	CLIP ANGLE	.050				6061-T6 ALUM.					
		1			(14)	-014	HINGE					6061-T6 ALUM.					
		1			(13)	-013	HINGE					6061-T6 ALUM.					
			1		(12)	-012	HINGE					6061-T6 ALUM.					
				1	(11)	-011	HINGE					6061-T6 ALUM.					
			1		(10)	-010	FIXING BRACKET	.093				LEXAN					
				1	(9)	-009	PLATE	.080				6061-T6 ALUM.					
				1	(8)	-008	PLATE	.080				6061-T6 ALUM.					
/				1	(7)	-007	MACHINED OUTER SUB-ASSY										
/				1	(6)	-006	MACHINED INNER SUB-ASSY										
/				1	(5)	-005	HINGE SUB-ASSY										
/				1	(4)	-004	FIXING BRACKET SUB-ASSY										
/				1	(3)	-003	PLATE SUB-ASSY										
/					(2)	-002	PLATE SUB ASSY										
/					(1)	-001	CHART HOLDER ASSY										
-007	-006	-005	-004	-003	-002	-001	ITEM NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL.SPEC.	ZONE				

[illegible]

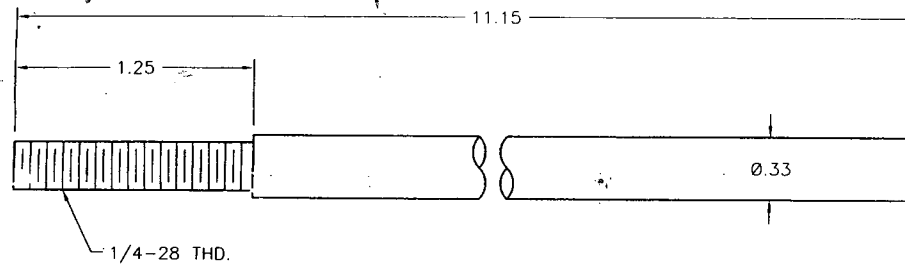
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

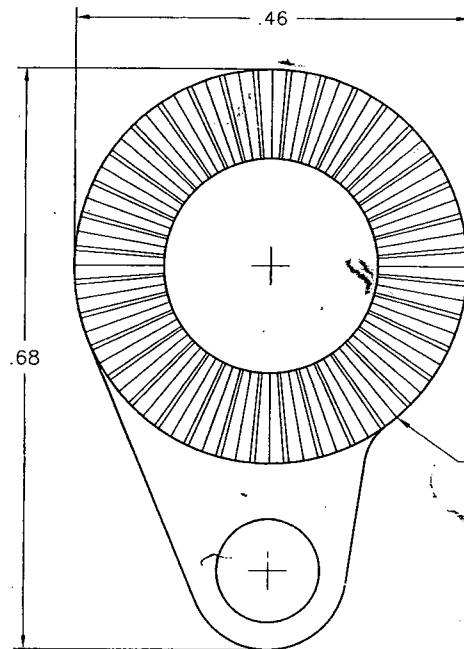
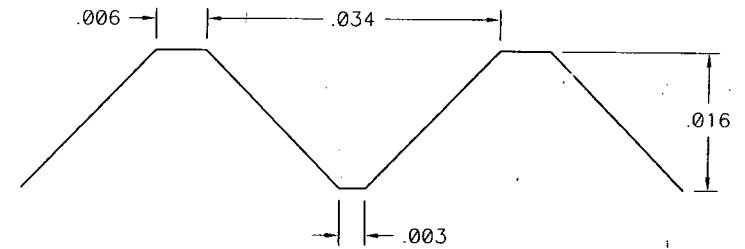
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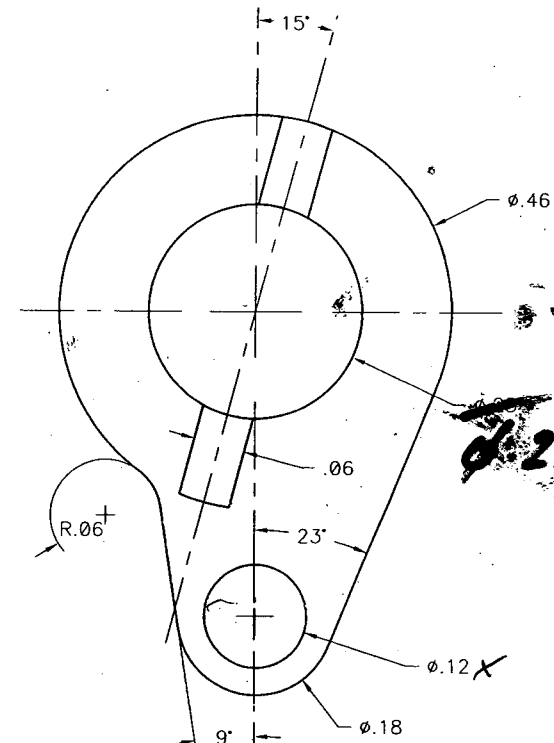
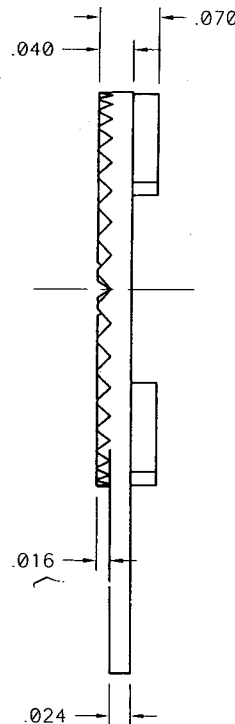
NOTE: Date & initial all entries



-023 PIN



36 POINTS,
EQ. SPCD.



-024 SERRATED ADJUSTMENT WASHER

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Era Helicopters LLC

TITLE	SIZE	DWG. NO.	REV.
SINGLE PILOT VFR CHART HOLDER, AW139	C	13939-1-290 SHT 10 OF 10	A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

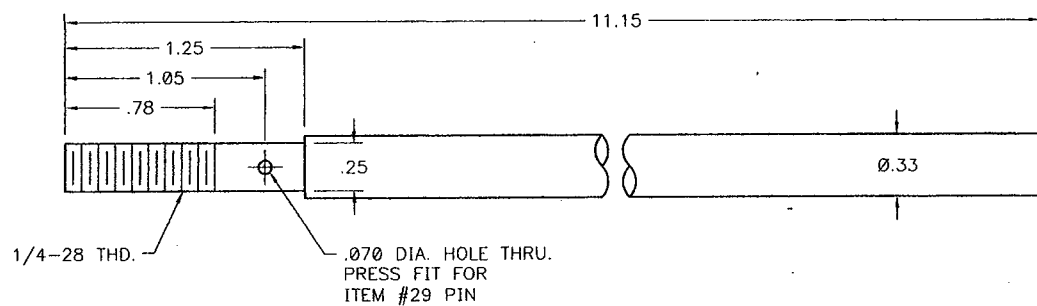
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

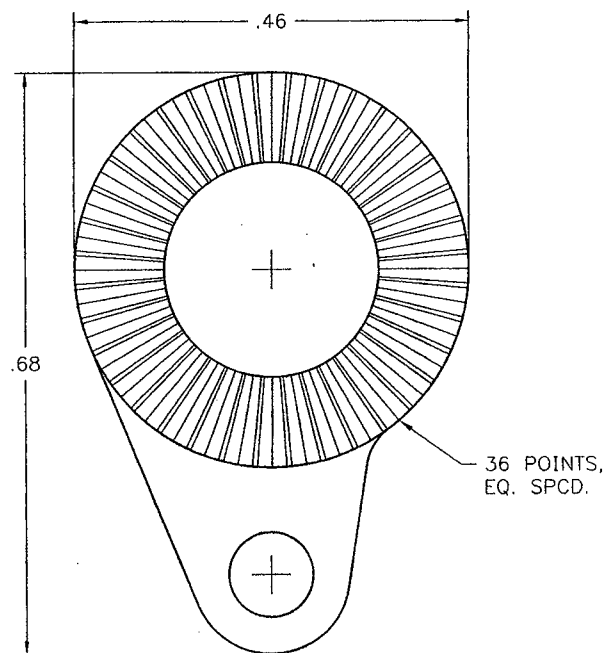
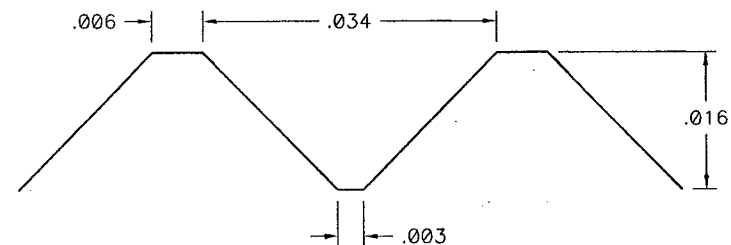
DART P/N	ERA P/N	Description
D4298-001	13939-1-290-001	CHART HOLDER ASSY
D4298-002	13939-1-290-002	PLATE SUB-ASSY
D4298-003	13939-1-290-003	PLATE SUB-ASSY
D4298-004	13939-1-290-004	FIXING BRACKET SUB-ASSY
D4298-005	13939-1-290-005	HINGE SUB-ASSY
D4298-006	13939-1-290-006	MACHINED INNER SUB-ASSY
D4298-007	13939-1-290-007	MACHINED OUTER SUB-ASSY
D4298-008	13939-1-290-008	PLATE
D4298-009	13939-1-290-009	PLATE
D4298-010	13939-1-290-010	FIXING BRACKET
D4298-011	13939-1-290-011	HINGE
D4298-012	13939-1-290-012	HINGE
D4298-013	13939-1-290-013	HINGE
D4298-014	13939-1-290-014	HINGE
D4298-015	13939-1-290-015	CLIP ANGLE
D4298-016	13939-1-290-016	CLIP STOP
D4298-017	13939-1-290-017	CLIP STOP MOUNT
D4298-018	13939-1-290-018	MACHINED INNER
D4298-019	13939-1-290-019	MACHINED OUTER
D4298-020	13939-1-290-020	KNOB
D4298-021	13939-1-290-021	MACHINE BOLT
D4298-022	13939-1-290-022	PIN TOPPER
D4298-023	13939-1-290-023	PIN
D4298-024	13939-1-290-024	SERRATED ADJUSTMENT WASHER

RELEASED
2010-12-15
W

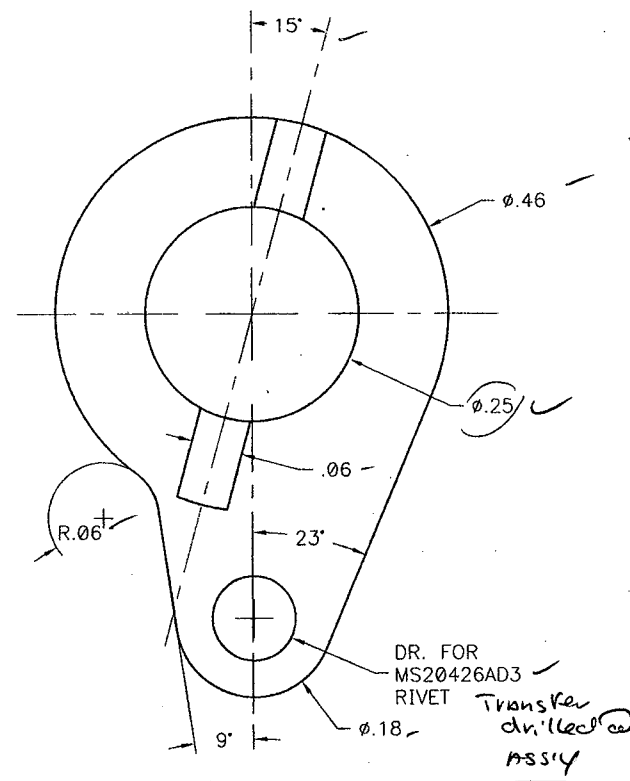
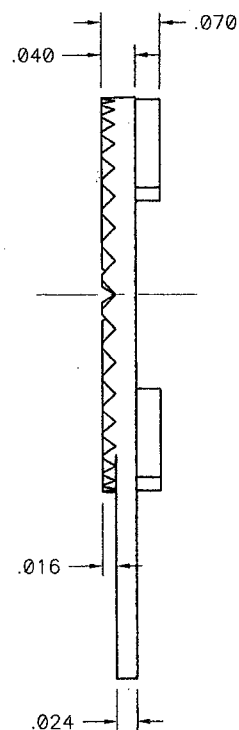
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REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	<i>W</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>E</i>	D4298	SHEET 1 OF 1
APPROVED	<i>W</i>	TITLE	SCALE
DE APPR.	<i>W</i>	CHART HOLDER (AW 139)	NTS
DATE	10.12.15	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



-023 PIN



-024 SERRATED ADJUSTMENT WASHER



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